



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2573

Job Sheet 186112



Part No: D2573

Job Qty: 1 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 11/19/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/19/18	0.00	0.00	Start Up Machining		SBL 18/11/11
100	CNC Vertical Machining	1 pcs		11/19/18	1.01	1.67	HAAS 1		SBL 18/11/11
110	Mill Conv	1 pcs		11/19/18	0.00	0.17	Mill Conv 1		SBL 18/11/11
130	QC	1 pcs		11/19/18	0.00	0.00	QC8		
140	HandFinish	1 pcs		11/19/18	0.00	0.05	HandFinish1		
150	Powdercoat	1 pcs		11/19/18	0.00	0.04	Powdercoat1		
160	QC	1 pcs		11/19/18	0.00	0.00	QC3		
170	Packaging	1 pcs		11/19/18	0.00	0.00	Packaging3		
180	QC21-SA	1 Ea		11/19/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	1 Ea (1 ea)	90-Start up Operation	5082092

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	1	3	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Outboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	

Plex 11/12/18 7:58 AM dart.leroux.jasor

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
14	Sa	DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com		
15	Sa	Container No: S126834 		
16	Sa	Part: D2573 Job No: 186112 Serial No/Batch: S126834		
17	Sa	Revision: Inspector: Exp Date:		
18	Sa	Instructions: Various STC's		
19	Sa	Date: 11/12/18		
20	Sa			
21	Sa			
22	Sa			
23	Sa			
24	Sa			
25	Sa			
26	Sa			
27	Sa			
28	Sa			
29	Sa			
30	Sa			
31	Sa			
32	Sa			
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: 18/11/12

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>186 112.</u> Part No. <u>D2573</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date : <u>2018/11/11</u>		Step #: <u>100</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval DAS 9 9-89 18-11-26																	
Description Work Order Deviation				Disposition																			
ran out of power end mill plunge in the part				Scrap destroy no replace.																			
								Completed By DAS 57582 9-89 18/11/12															
								Lead hand / Supervisor Approval Verification <i>[Signature]</i> 18/11/12															
				QC / QA Coordinator Approval DAS 36 9-89 9-89 NOV 12 2018																			

Root Cause			FAULT CATEGORY		
Environment ☒	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☒ Over/Under tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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